

cutting a flat metal blank in such a way that it has a ring-shaped section/;

deforming said ring-shaped section in such a way that it acquires a hollow profile which in cross-section encloses an angle of more than 180°, and

said deforming step is carried out at least partially in that said ring-shaped section is moved between two rotatable rollers, said deforming step including a step in which said flat ring-shaped section is deformed by drawing in such a way that it acquires an essentially U-shaped profile.

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14. The method according to claim 13, wherein said U-shaped profile has two legs of differing lengths and said rollers deform the longer one of said legs.

15. The method according to claim 14, wherein said rollers bend said radially outer leg radially inwards.

16. The method according to claim 13, wherein at least one of said rollers has a stepped peripheral surface.

17. The method according to claim 13, wherein said profile encloses at least approximately 270° after said deformation step.

18. The method according to claim 13, wherein before said deformation step, a number of holes is stamped into said ring-shaped section.

~~16.~~ ¹ A method of producing a skeleton for a steering wheel rim made of sheet metal, said method comprising the steps of:

cutting a flat metal blank in such a way that it has a ring-shaped section, said metal blank having a section for defining at least one spoke and a section for defining a hub, said sections continuing into each other in one piece,

deforming said ring-shaped section in such a way that it acquires a hollow profile which in cross-section encloses an angle of more than 180°,

said deforming step is carried out at least partially in that said ring-shaped section is moved between two rotatable rollers, and

by means of drawing, said ring-shaped section first acquires a U-shaped profile with a radially outer longer leg that is bent radially inwards between said rollers, said section for said spoke being bent into a U-shaped ^{profile} by said drawing.

~~20.~~ ⁸ A method of producing a skeleton for a steering wheel from sheet metal, said method comprising the following steps:

providing a flat metal blank,

cutting the flat metal blank to form a ring-shaped section,

forming a skeleton for a steering wheel rim by deforming said ring section in such a way that ^{it} ~~is~~ acquires a

hollow profile which in cross-section encloses an angle α of more than 180° , and

said forming step comprising at least partially deforming said ring-shaped section by moving said ring-shaped section between two rotatable rollers.

9 21. The method according to claim 8, wherein said flat metal blank includes a plurality of holes in said ring-shaped section.

10 22. The method according to claim 8, wherein said flat metal blank includes a central hub section and a plurality of spoke sections interconnecting said hub section and said ring-shaped section, said plurality of spoke sections being spaced apart from each other by empty spaces.

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Concluded